

Date: Wednesday, 12/11/2008 1:29:52 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	350/355 AS X-TUBE FWD
<b>Job Number</b> :	43336		
<b>Estimate Number</b> :	12485		
<b>O. Number</b> :		<b>Part Number</b> :	D350748101
<b>This Issue</b> :	12/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	N/A
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41583	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	
	CROSSTUBES	<b>Due Date</b> :	02/12/2008
<b>Written By</b> :		<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b> :	DD 08.11.12		
<b>Comment</b> :	Est Rev:A New Issue 06-07-05 JLM Est Rev:B Update qty of MS21042L5 06-09-12 KJ Est Rev:C Rev B 07-11-15 DD Est Rev D Combined manufacturing 08.04.02 EC verified by: DD Est Rev:E 08-06-24 revD as per dwg DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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Handwritten: 08/12/08



**Comment:** Photocopy bluefile & type labels per PPPD350-748-101 CHG001

2.0	D350748141TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 CROSSTUBE TURNING DETAIL  
 batch B42404

Handwritten: DP 8-11-20

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE  
 Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

Handwritten: DP 8-11-20

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

Handwritten: 08-11-21

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,  
 Set-up drill table as per QSI 010

Handwritten: ET 08 11 25

2-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43336

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Engrave Part # and Batch # as per Dwg D350-748-141

87-08-11-25

4-Remove all marks from tube within limits of D350-748-141

- AWM 8-11-26

5- Apply a light coat of LPS3 on the interior of tube

Batch: m109539

- FL 08/11/27 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

S 08/11/27 (1)

7.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7700

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C 08/11/27

(1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

P 08/11/27 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-23 (1)

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

87-08-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43336

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC14	INSPECT SPRAY PAINT
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ml 08 12 24



①

Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

12.0	D35021	Support
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch: 42968

ml 08 12 29

13.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

ml 08 12 29

14.0	ALS41032225	Insert
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch: 109817

ml 08 12 29

15.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch: 105442

ml 08 12 29

16.0	MS2192020	Clamp (per MIL-DTL-8783C)
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 109715

ml 08 12 29

17.0	MS27039110	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

Batch: 18836

ml 08 12 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43336

Part Number: D350748101

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 08 12 29 (1)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.30 (1)

CHECKED FOR FITNESS → ACCEPTABLE

09.03.25

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D35001 Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

350 SADDLE

Batch: 41602

SP

22.0 D35011 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

BUSHING

Batch: 1539726

SP

23.0 AN46A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M109545

SP

24.0 AN441A bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M109632

8/12/30

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43336

Part Number: D350748101

Job Number:



Seq. #: Machine Or Operation: Description :

25.0 AN532A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109752

SD

26.0 AN960JD416 Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M109249

SD

27.0 AN960JD516 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109752

SD

28.0 MS21042L4 Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M10845

SD

29.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

SD

30.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

31.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-101

Location: A

PPP Rev: 2/1/5

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43336

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

208/01/06

Job Completion



mf 09-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

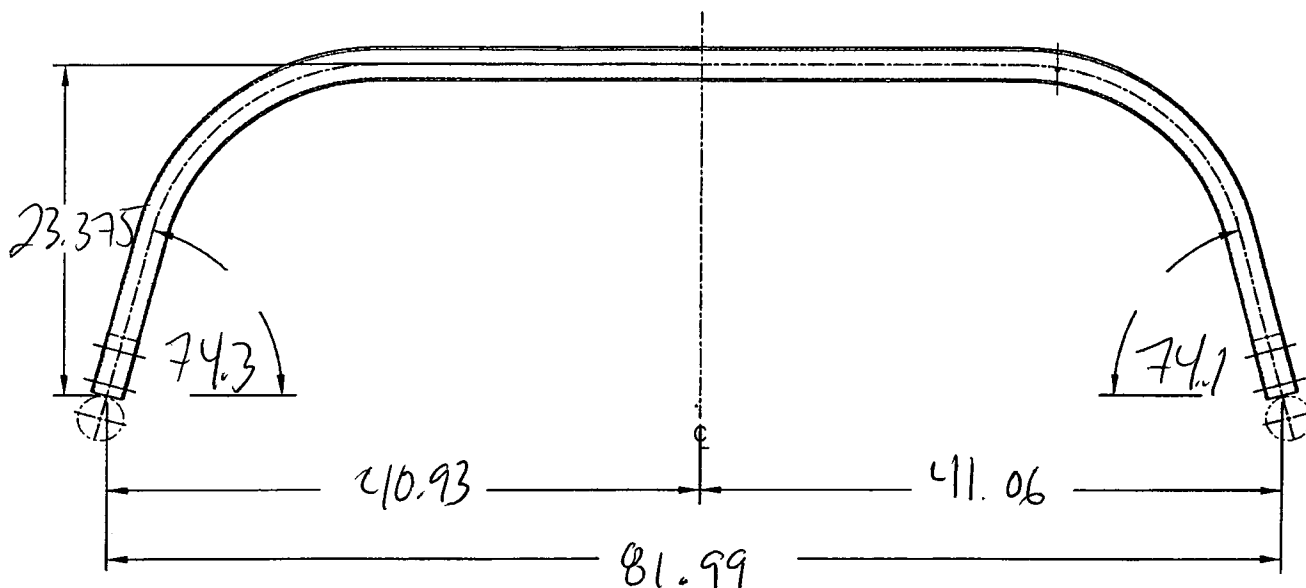
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	43336
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
MAX TWIST = 0.325" → ACCEPTABLE # 09.03.25

QC15 Inspection	
Date	10/11/21

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**DART**

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

**RELEASED**06.10.31 *HA*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125  
FINISHED LENGTH =  $110.27 \pm 0.06$
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR  $\varnothing 0.297$  HOLE.

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43336

**UNDER REVIEW!**

07.02/16 *HA*  
CUFF REM. REDUCED  
OK 07.11.22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

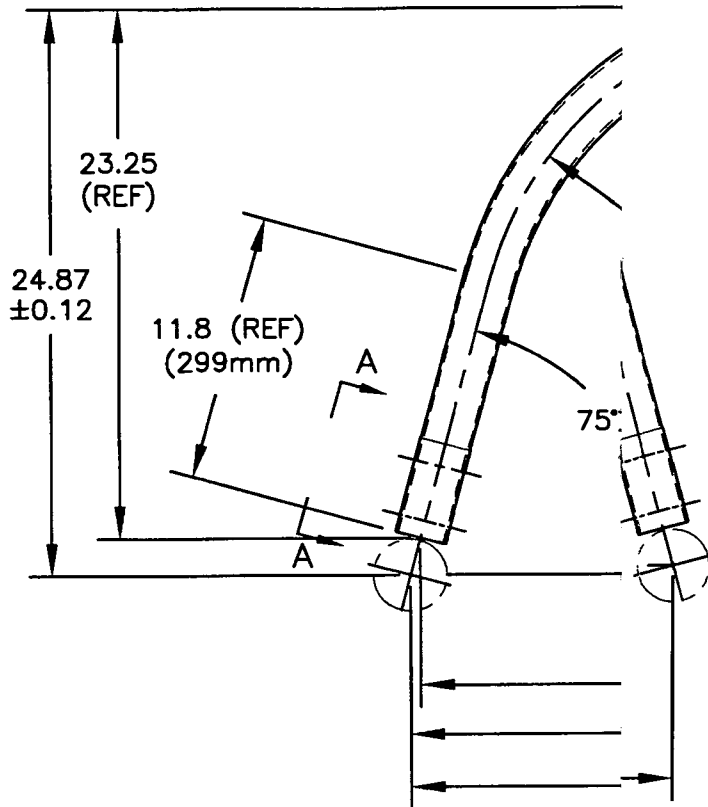
**NOTE:** Date & initial all entries



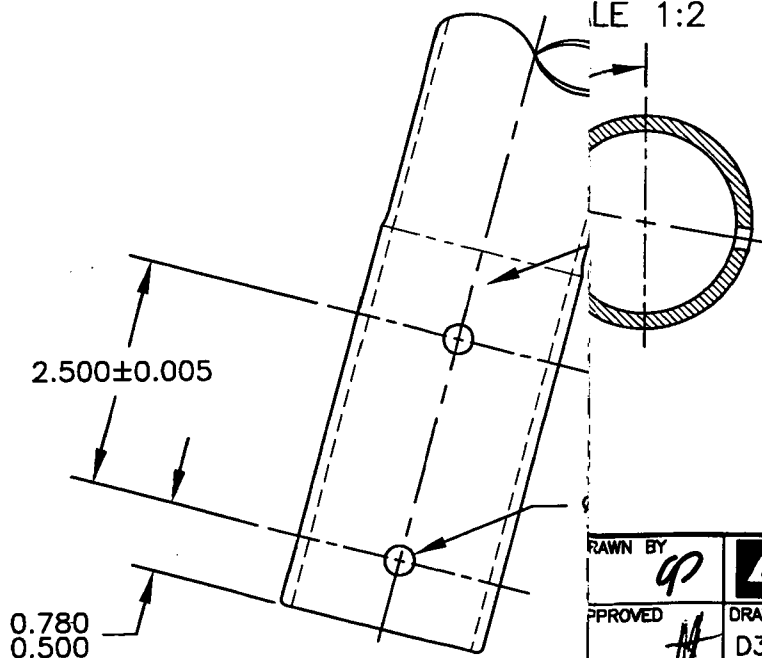
1)  9

IN STRIP (2 PLACES)

 8



ON C-C  
SCALE 1:2





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43336

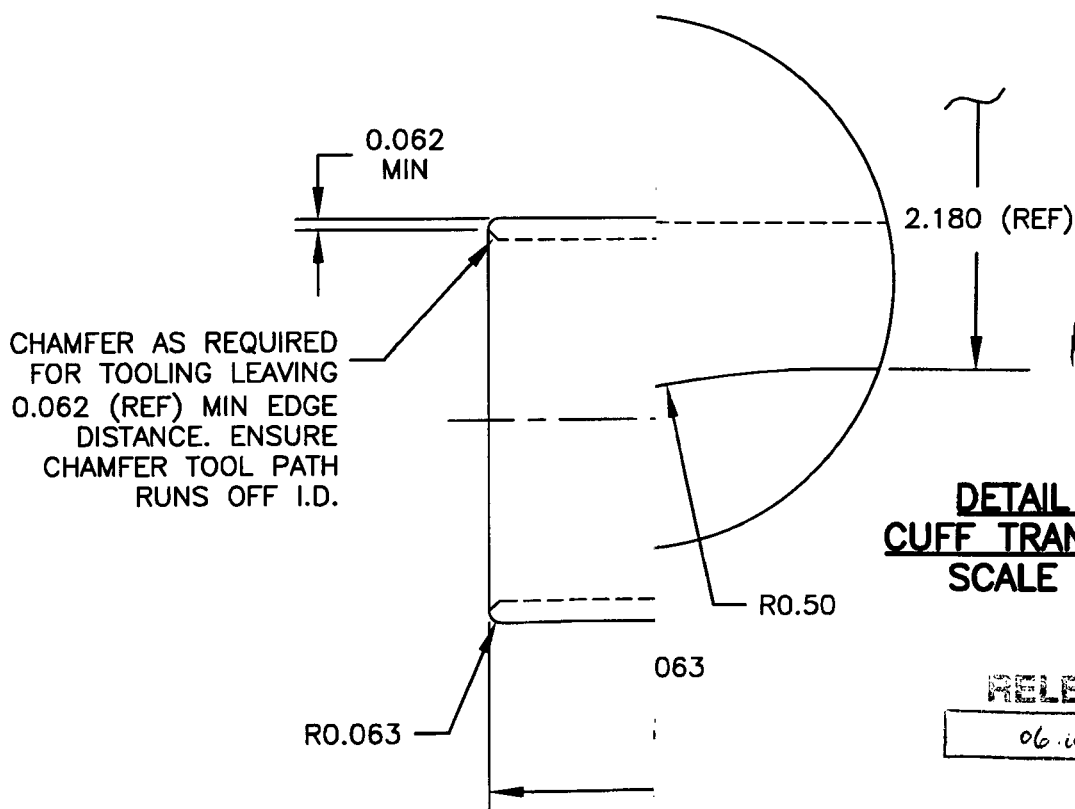
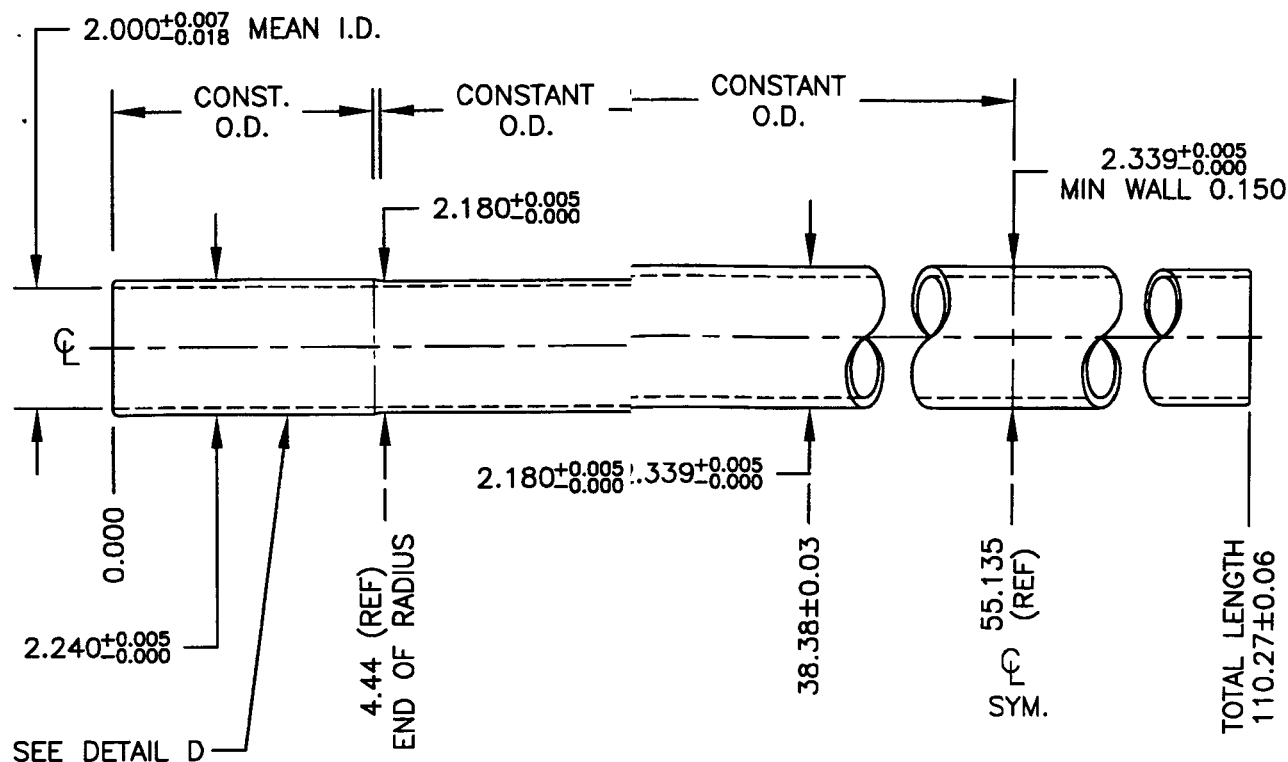
**UNDER REVIEW**

07.02.16  
CUTTING REDUCED  
OK 07.11.22

**RELEASED**

06.10.31

DRAWN BY 	<b>DART</b>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA
APPROVED 	DRAWING NO. D350-748-141	REV. D SHEET 2 OF 3
	TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:8



**UNDER REVIEW**

07.02/16/18

**DETAIL E:**  
**CUFF TRANSITION**  
**SCALE 9:1**

**RELEASED**

06.10.31

AWN BY qp	<b>DART</b>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA
PROVED #	DRAWING NO. D350-748-141	REV. D SHEET 3 OF 3
	TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:3

# Packing Slip



## Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

**Sold To:**

Dart Aerospace Ltd.  
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

**Ship To:****INVOICE NUMBER:**

42387

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
00007700	Dec-08-2008	NET 30 DAYS	10071 6547 RT0001		Dec-17-2008

Item #	Qty	P/N & Description	
1	1 EA	SKID	S/N B43336
		P/N d350-748-101	W/O 82376
2	1 EA	SKID	S/N B43337
		P/N d350-748-101	W/O 82377
3	1 EA	SKID	S/N B43339
		P/N d350-748-101	W/O 82378
4	1 EA	SKID	S/N B42538
		P/N d350-748-101	W/O 82379

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Dec-17-2008

**CONSIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 82376  
**INVOICE #:** 42387

**CONTRACT OR  
PURCHASE ORDER # 00007700**

**DESCRIPTION:** SKID

**QTY** 1

**P/N #** d350-748-101

**S/N #** B43336

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART # 9921. MPI  
INSPECTED IAW ASTM E 1444. CADMIUM PLATED IAW AMS-QQ-P-  
416B, TYPE 2 YELLOW, CLASS 2. BAKE HEAT CHART # 9967.**

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



A large, stylized handwritten signature in black ink.